

Work Order ID 52986

October 20, 2009 11:54:48 AM



Page 1

Item ID: D3453-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Clevis

Start Date: 22/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 28/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *PA*

Date: *09-10-20*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3453

Rev A

100

0.00



Doosan

Doosan Lathe

Memo

1-Turn as per Folio FA577

Rev: *PA*

Dwg D3453 Rev: *B*

2- Deburr as per dwg D3453

0.00

09.10.29

10

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

09.10.29 *(10)*

10

160

QC8- Inspect parts - second check

0.00



QC

Quality Control

Memo

0.00

09/10/29

10

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Cust Item ID:

Required Date: 28/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 92

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Per 9/10/30 (10)09/10/30
mf
09-10-30

Picklist Print

October 20, 2009 11:54:56 AM

Page 1

Work Order ID: 52986

Parent Item: D3453-1RevB

Parent Item Name: Clevis

Comments:

Start Date: 22/10/2009

Required Date: 28/10/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R1.250		Purchased	No			100	f	73.5000	2.8800			

304 round bar 1.250

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

105872

108156

111018

73.5

12.5

11.5

49.5

09.10.29

2.85

DART AEROSPACE LTD		Work Order: 52986
Description: <i>devs</i>		Part Number: 3453-1
Inspection Dwg:	Rev: <i>B</i>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☒ Prototype

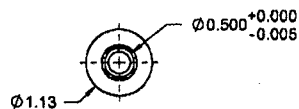
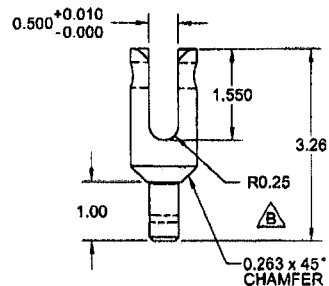
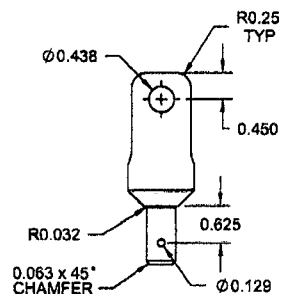
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R. 25 <i>typ.</i>	<i>+/- .030</i>	R. 25	<i>/</i>			
. 438 <i>Ø</i>	<i>+ .006 - .001</i>	. 438	<i>/</i>			
. 450	<i>+/- .010</i>	. 450	<i>/</i>			
R. 032	<i>+/- .010</i>	R. 032	<i>/</i>			
. 625	<i>+/- .010</i>	. 622	<i>/</i>			
. 063 x 45°	<i>+/- .010</i>	. 063	<i>/</i>			
. 129 <i>Ø</i>	<i>.005 - .001</i>	. 129	<i>/</i>			
. 500	<i>+0.0 - .005</i>	. 498	<i>/</i>			
1.13	<i>+/- .030</i>	1.127	<i>/</i>			
. 500	<i>+ .010 - 0.0</i>	. 502	<i>/</i>			
1.550	<i>+/- .010</i>	1.551	<i>/</i>			
<i>Ø</i> R. 25	<i>+/- .030</i>	R. 25	<i>/</i>			
1.00	<i>+/- .030</i>	. 999	<i>/</i>			
3.26	<i>+/- .030</i>	3.261	<i>/</i>			
. 263 x 45°	<i>+/- .010</i>	. 263	<i>/</i>			

Measured by: <i>[Signature]</i>
Date: <i>09.10.29</i>

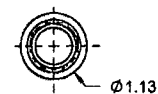
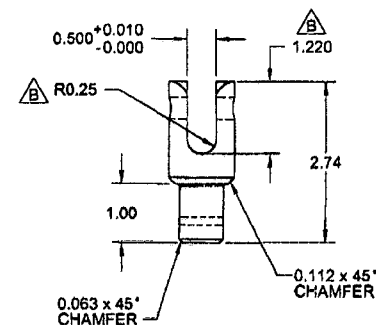
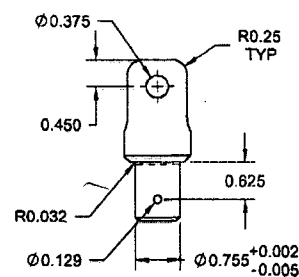
Audited by: <i>[Signature]</i>
Date: <i>05/10/29</i>

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3453-1 CLEVIS



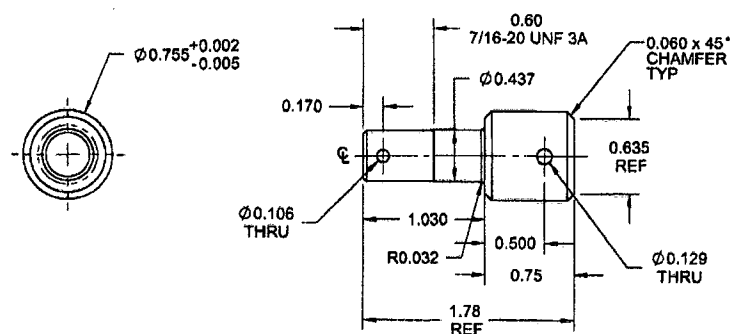
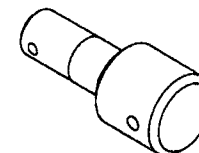
D3453-3 CLEVIS

RELEASED
52980
57/06/23/WP

D3453-1/3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3453-1 = 0.41 lbs
D3453-3 = 0.41 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS; R0.25 WAS 0.050 (ZN C5-1, C2-1); 1.220 WAS 1.175 (ZN D1-1); REF PAR 09-018	RF	09.05.21
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3453	SHEET 1 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CLEVIS	NTS
DATE	09.05.21	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	




D3453-5 PLUG

52986

RELEASED

D3453-5 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3453	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CLEVIS	NTS
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